

Work Order ID 61882

Wednesday, September 08, 2010 3:27:30 PM

PRELIMINARY ISSUE



Page 1

Item ID: D4174-3

Accept



Setup Start



Revision ID: PRELIM

Item Name: Connector Plate Doubler

Stop



Start Date: 9/8/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

PAI

Date: 10-9-08

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4174

PA1

100

0.00



Waterjet

Memo

0.00

10-9-13

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: PA1

Prog Rev: PA1

2-Deburr if necessary

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

10-9-13

Quality Control

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Stop



Item Name: Connector Plate Doubler

Start Date: 9/8/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00 - inspect to PA1



QC

Memo

0.00

Qty only
S10013 (x4)

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

BR 10-9-14

(4)

φ

Hand Finishing

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

Start Time: 1:50
Oven Temperature: 320°
Finish Time: 2:20

BR 10-9-16

(K)

φ1

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Page 3

Item ID: D4174-3

Revision ID: PRELIM

Item Name: Connector Plate Doubler

Start Date: 9/8/2010 Start Qty: 3.00

Required Date: 9/13/2010 Req'd Qty: 3.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

→ JH

10/09/10

4

0

160



Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

composites

filled

BT 10-10-01 (43)

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/10/04

10/10-01 (3)

POSITIVE RECALL

EFFECTIVE 10/09/09 AUTH W

RELEASED DATE 10/10/01

For Release Date

Date 10/09/29

Picklist Print

Wednesday, September 08, 2010 3:27:34 PM

Page 1

Work Order ID: 61882

Parent Item: D4174-3

Parent Item Name: Connector Plate Doubler




Start Date: 9/8/2010

Required Date: 9/13/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 10.09.08 new issue verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063  6061-T6 .063 Sheet		Purchased		No		100	sf	104.9340	0.11	0.347368		.45 B 10-9-13	

Location

Loc Qty

Loc Code

MAT21

104.934

113608

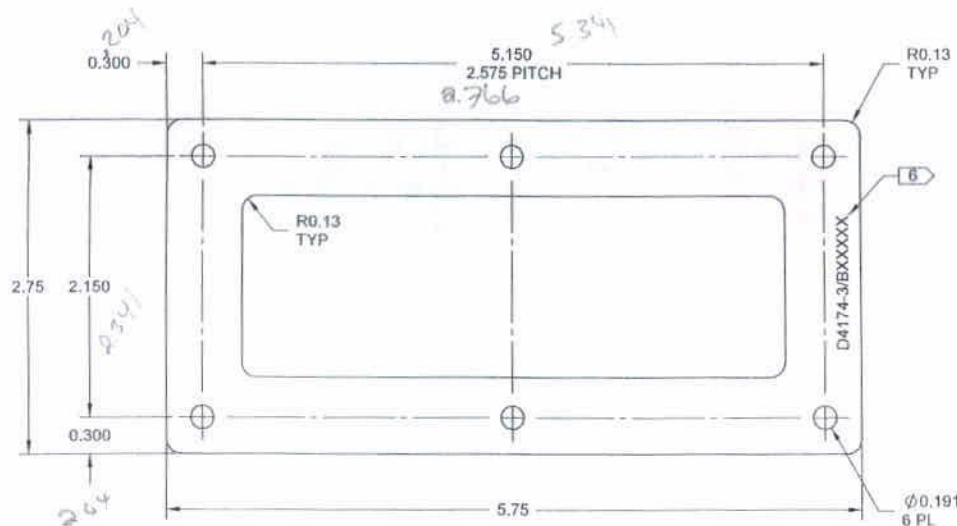
104.934

113608

Q

Route / Barn / Axf

DONE



D4174-3 CONNECTOR PLATE DOUBLER

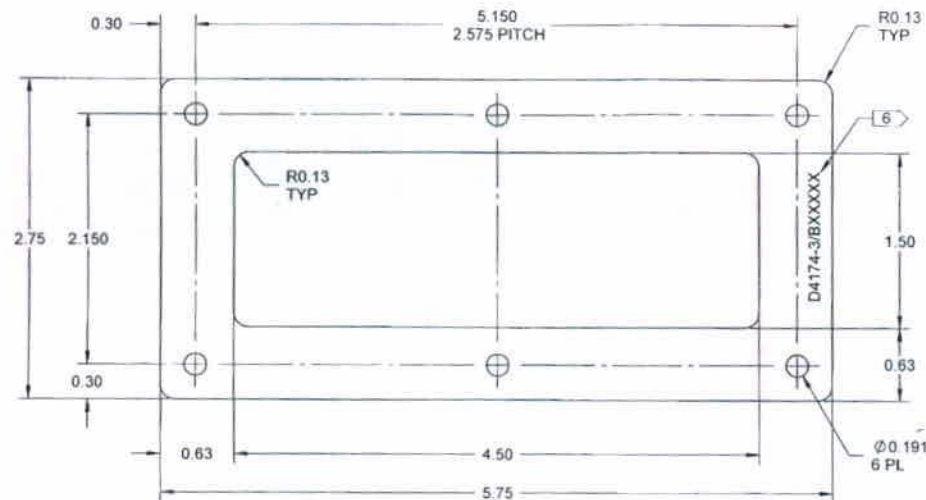
PRELIMINARY ISSUE

10.09.08

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.08 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4174	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CONNECTOR PLATE	NTS
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D4174-3 CONNECTOR PLATE DOUBLER

NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.06 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR		D4174	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CONNECTOR PLATE	NTS
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RELEASED
2010-09-29
MP